

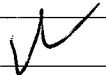
Work Order ID 119835

119835

Page 1

May-27-14 11:31:25 AM

Item ID: D5032-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: B119835 Stop *NS2*
 Item Name: Doubler
 Start Date: 5/27/14 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5032	A								

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

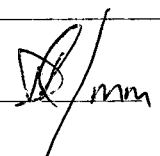
Prog Rev: A

2-Deburr if necessary

0.00

73

14/06/01



120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

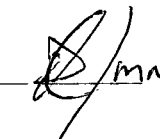
Quality Control

Memo

0.00

73

14/06/01



Work Order ID 119835

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May-27-14 11:31:25 AM

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 Item Name: Doubler
 Start Date: 5/27/14 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DAS 16 9-89	14/6/07		(73) conts			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				73	7/6/14-2		
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00	DAS 27 9-89	14/6/13		73			

Work Order ID 119835

119835

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May-27-14 11:31:25 AM

Item ID: D5032-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 5/27/14 Start Qty: 60.00

60

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Identify as per dwg & Stock Location: 529 0.00

160

Packaging Memo 0.00

Packaging

73x SP 14-6-3

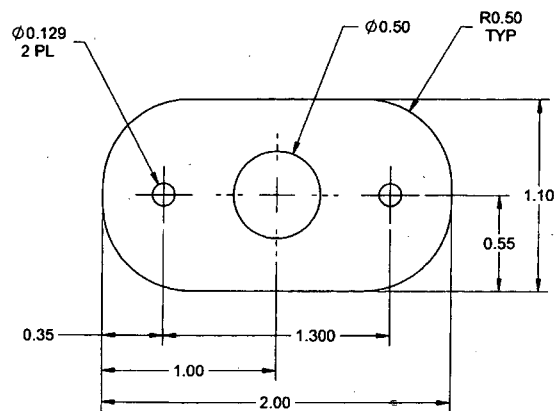
170 QC21- Final Inspection - Work Order Release 0.00

170

QC Memo 0.00

Quality Control

MLJ 14-06-04
MLJ 14-06-04



D5032-3 DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	D	D5032	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOUBLER	NTS
DATE	13.12.09	<small> COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

RELEASED
2013-12-23
125

W/O 119835

